

Oct 10

Work Order ID 136945

136945

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September 21, 2015 4:08:05 PM

Item ID: D3278-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Support Assembly
Start Date: 9/28/2015 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 10/30/2015 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: SH Date: 20150924 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3278	Rev C

100		0.00
100	Small Fab	
Small Fab	Memo	0.01
Small Fab	Rivet spacers with support as per Dwg D3278.	

20x _____ 15/10/19 DAS 36 9-89

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.01
Quality Control		

DAS
30
9-89

(20)

OCT 19 2015

120		0.00
120	Small Fab	
Small Fab	Memo	0.01
Small Fab	Assemble support as per Dwg D3278.***DO NOT TIGHTEN BOLTS***Identify as D3278-041	

20x _____ 15/10/19 DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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Item ID: D3278-041 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 9/28/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/30/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130						(20)			
QC	Memo	0.01							
Quality Control									OCT 19 2015
140	Identify as per dwg & Stock Location: <u>51 S22</u>	0.00							
140						20			DAS 27 9-89
Packaging	Memo	0.00							
Packaging									OCT 20 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									15/10/2015
QC	Memo	0.03							
Quality Control									

20151020

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

Picklist Print

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Work Order ID: 136945

136945

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 9/28/2015

Required Date: 10/30/2015

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 *D3278-1* Support		Manufactured	No			100	Each	1.0000	1	20		15/10/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1					
				129533				1					
D3278-2 *D3278-2* Support		Manufactured	No			100	Each	0.0000	1	20		15/10/19	DAS 36 9-89
D3278-3 *D3278-3* Spacer		Manufactured	No			100	Each	29.0000	1	20		15/10/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				29					
				132761				29					

B137173 (19x)

B137317 (20x)

20

Picklist Print

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Work Order ID: 136945

136945

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 9/28/2015

Required Date: 10/30/2015

Start Qty: 20.00

Required Qty: 20.00

MS21042L4

Purchased

No

100

Each

1,712.000

2

40

MS21042L4

Locknut

15/10/19

DAS
36
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1428

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1248

40



AN4-13A

Purchased

No

120

Each

208.0000

2

40

AN4-13A

Bolt

15/10/19

DAS
36
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

ST344

188

m132551

188

M131677
23x

M133284
17x

Picklist Print

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Work Order ID: 136945

Parent Item: D3278-041

Parent Item Name: Support Assembly

136945

D3278-041

Start Date: 9/28/2015

Required Date: 10/30/2015

Start Qty: 20.00

Required Qty: 20.00

D2230-1 Manufactured No

120 Each 101.0000 2 40

D2230-1

Mounting Lug

**

15/10/19 DAS 36 9-89

Location

Loc Qty

Loc Code

FG

4

84136

4

ST521

97

115306

47

134015

50

MS20426AD3-6

Purchased No

120 Each 630.0000 4 80

MS20426AD3-6

Rivet

**

15/10/19 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

630

M120123

630

120 Each 2,605.000 4 80

NAS1149D0463J

Purchased No

NAS1149D0463.J

WASHER

**

15/10/19 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M133077

1000

ST269

1564

M129682

86

M130799

371

M132035

94

M132317

125

M132677

888

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Shop Packet Print

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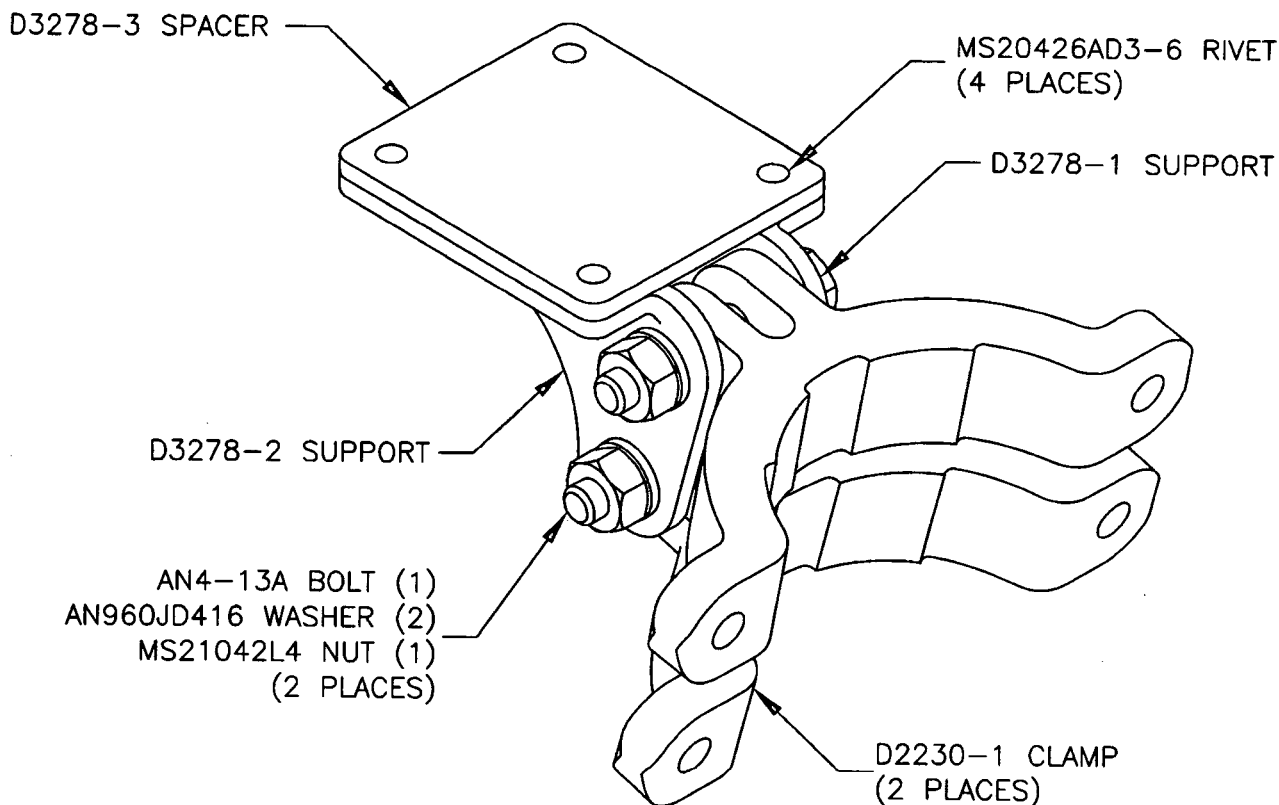
20150921.

34 136945

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

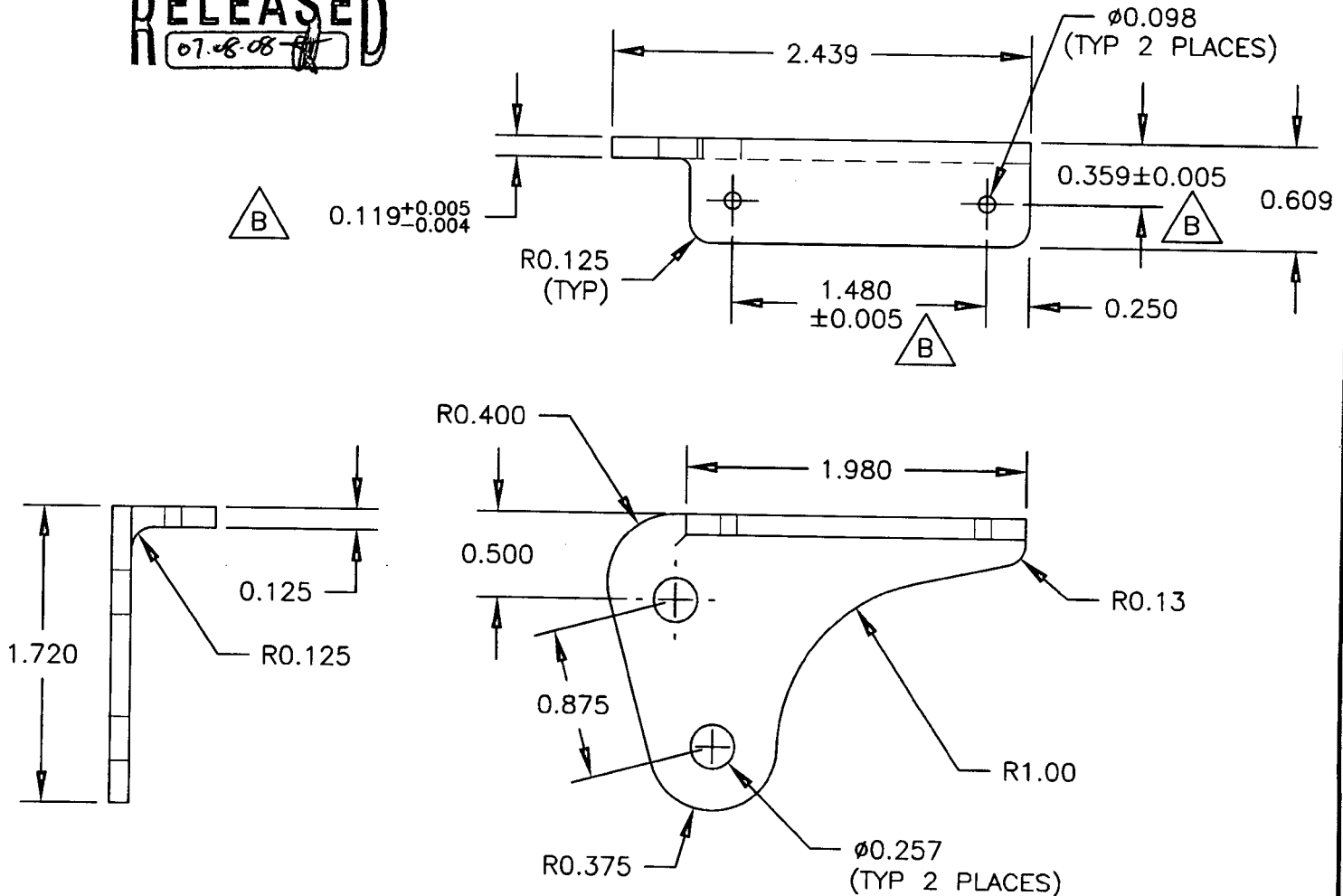
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

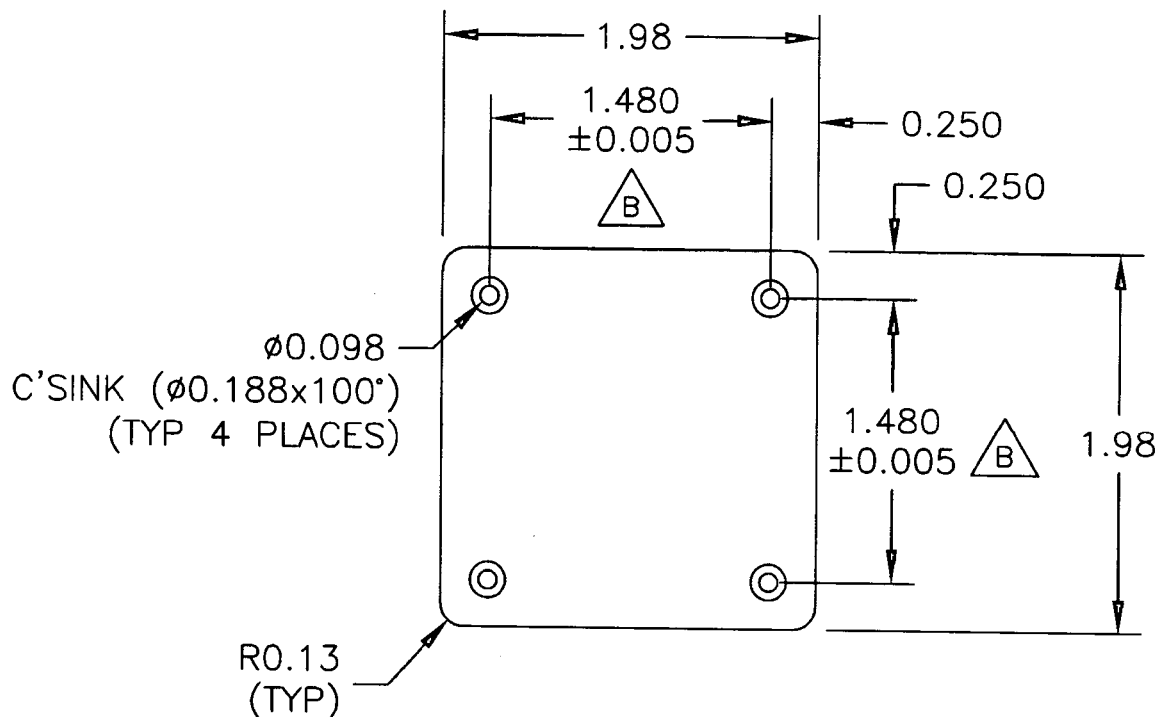
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CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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